

Work Order ID 66423

February 14, 2011 11:45:56 AM



Page 1

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 2/14/11 Start Qty: 3.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 3.00

Customer:

Reference:

Run Start



Approvals: Process Plan: CY Date: 11/02/14

Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4034

B

100 Weld per dwg A/R S.S. rod Batch: M114649 0.00



Large Fab

Memo

0.00

Large Fab

1- Assemble ribs to hoop and weld as per dwg DT9564 ✓

2- Weld bushing in rib as per dwg ✓

JS 11.02.22 (3x)

110

QC9- Inspect visual per QS1004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

PC 11.02.22

120

QC5- Inspect part completeness to step on W/O 0.00



QC

Memo

0.00

Quality Control

S 11.02.23

(x3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66423

February 14, 2011 11:45:56 AM



Page 2

Item ID: D4034-043

Accept



Setup Start



Revision ID:

Stop



Item Name: Fwd Upper Rib Assembly

Start Date: 2/14/11 Start Qty: 3.00



Cust Item ID:

Required Date: 2/18/11 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Backset cell

Packaging

Memo

0.00

Packaging

by

11-02-22

(3x)

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/02/23

11-02-23

(3)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 14, 2011 11:45:55 AM

Page 1

Work Order ID: 66423

Parent Item: D4034-043

Parent Item Name: Fwd Upper Rib Assembly





Start Date: 2/14/11

Required Date: 2/18/11

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 09.11.23 verified by:EC
per dwg revA 10.03.15 verified by:EC
PER DWG REV.B DD VERF:EC
IPP Rev:B as
IPP Rev:C 11.01.19 AS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4034-1  Rib		Manufactured	No			100	Each	4.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>65925</div> </div> <div> <div>Loc Qty</div> <div>4</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D4034-5  Rib		Manufactured	No			100	Each	0.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>58974</div> <div>64920</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>1</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D2327-3  Spacer Bushing		Manufactured	No			100	Each	11.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>58974</div> <div>64920</div> </div> <div> <div>Loc Qty</div> <div>11</div> <div>1</div> <div>10</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D4021-7  Hoop		Manufactured	No			100	Each	7.0000	1	3			
<div> <div>Location</div> <div>WA</div> <div>58039</div> <div>65923</div> </div> <div> <div>Loc Qty</div> <div>7</div> <div>1</div> <div>6</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													

B66108 (1x) *JS* 11.02.22

(2x)
B66421 (3x) *JS* 11.02.22

B66087 3x *JS* 11.02.22

JS 11.02.22

3x

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

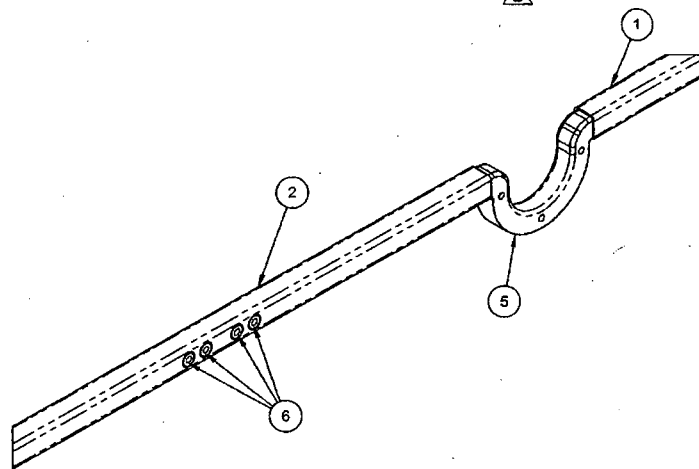
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

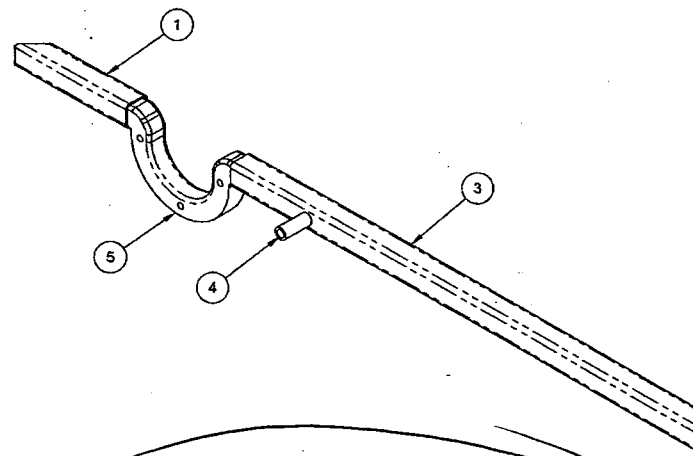
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D4034-041	AFT UPPER RIB ASSY
		X	D4034-043	FWD UPPER RIB ASSY
1	1	1	D4034-1	RIB
2	1		D4034-3	RIB
3		1	D4034-5	RIB
4		1	D2327-3	SPACER BUSHING
5	1	1	D4021-7	HOOP
6	4		D4021-9	BUSHING



D4034-041 AFT UPPER RIB ASSY



D4034-043 FWD UPPER RIB ASSY

RELEASED
R 2011-01-18
M

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 66423

CZ11/02/14

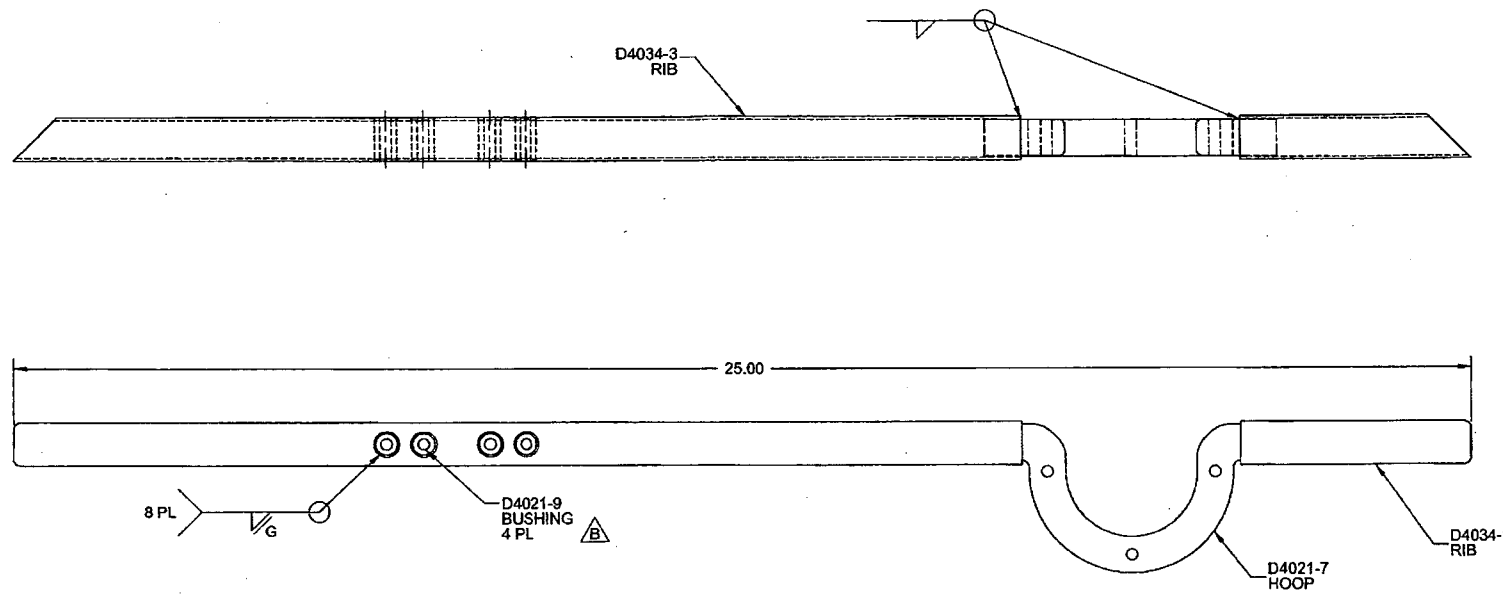
B	ADDITIONAL HOLES ADDED ON D4034-3 RIB	SC	10.12.20
A	NEW ISSUE	AJS	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS		
DRAWN	SC		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.20		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4034** REV. B
SHEET 1 OF 4

TITLE **UPPER RIB ASSY, BASKET BASE** SCALE **NTS**

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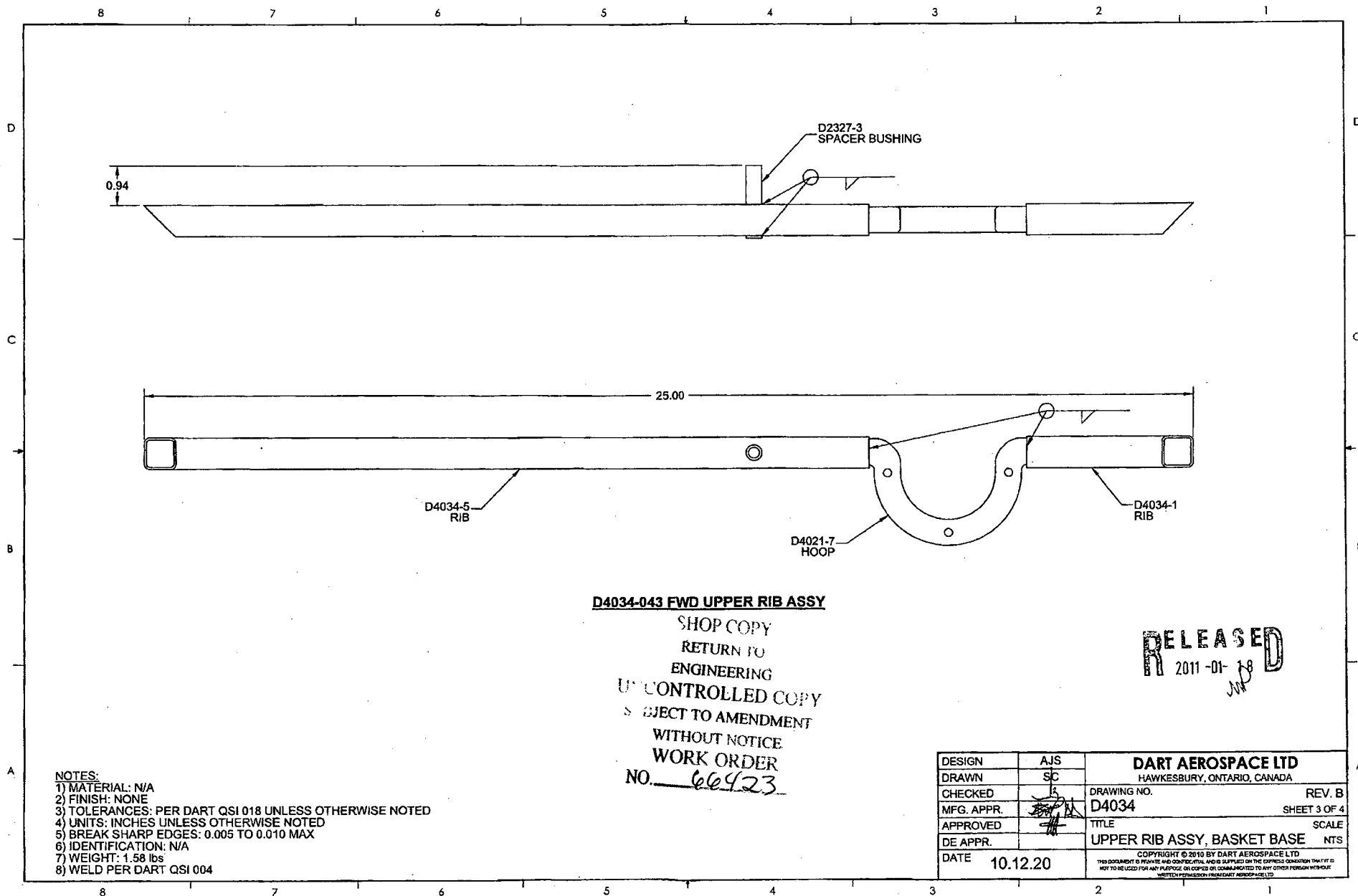
D4034-041 AFT UPPER RIB ASSY B

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UNCONTROLLED COPY
WITHOUT NOTICE
WORK ORDER
NO. 66423

RELEASED
R 2011-01-18

- NOTES:**
 1) MATERIAL: N/A
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: N/A
 7) WEIGHT: 1.61 lbs
 8) WELD PER DART QSI 004

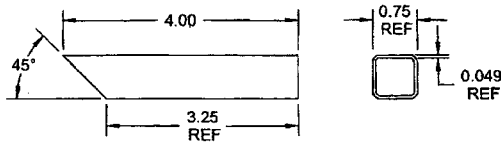
DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JS	DRAWING NO.	REV. B
MFG. APPR.	JS	D4034	SHEET 2 OF 4
APPROVED	JS	TITLE	SCALE
DE APPR.	JS	UPPER RIB ASSY, BASKET BASE	NTS
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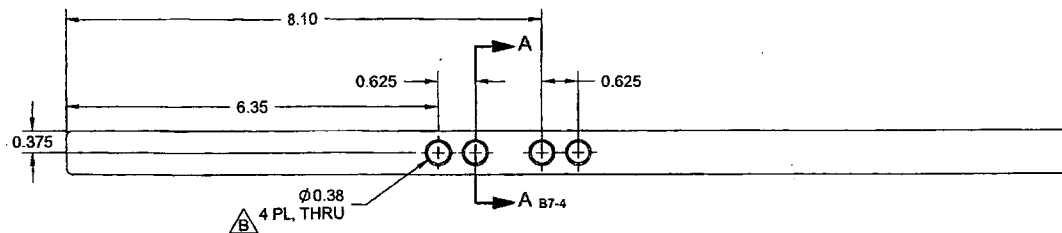
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D

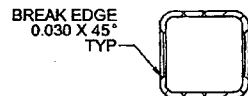
D



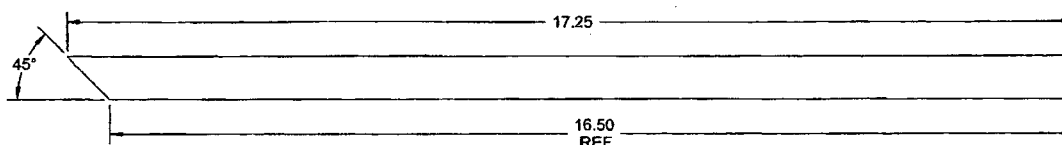
D4034-1 RIB



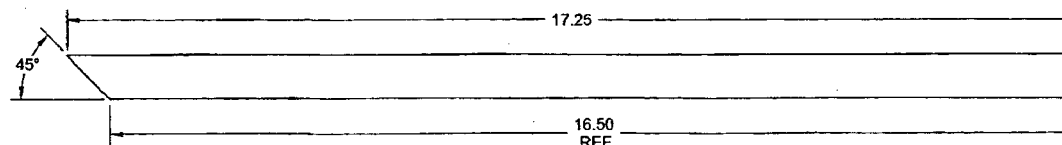
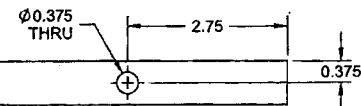
D4034-3 RIB



SECTION A-A D4-4



D4034-5 RIB



RELEASED
2011-01-10

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT -1: 0.13 lbs
-3 & -5: 0.62 lbs

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WITHOUT NOTICE
WORK ORDER
NO. 66423

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4034	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		UPPER RIB ASSY, BASKET BASE	NTS
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8 7 6 5 4 3 2 1